

Work Order ID 140248

Wednesday, January 20, 2016 2:19:45 PM

140248

Cut ASA P

Shortage
For Shippers

Page 1

Item ID: D2369-3

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Locator Plate

Stop

NS2

Start Date: 12/17/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/17/2015 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: MLSDate: JAN 20 2016

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2369

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo:

0.02

FLOW CNC Waterjet

1-Cut as per Dwg D2369

Dwg Rev: BProg Rev: B

2-Deburr if necessary

(10)

DC 16/02/02

110

0.00

110

QC2-Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

(10)

DC 16/02/02

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Item ID: D2369-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Locator Plate
Start Date: 12/17/2015 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 12/17/2015 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 38 9-89
120						(10)			
QC	Memo	0.00							
Quality Control									FEB 02 2016
150	Identify as per dwg & Stock Location: <u>5225A</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									FEB 04 2016
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.02							
Quality Control									FEB 04 2016

520160204

Picklist Print

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Work Order ID: 140248

140248

Parent Item: D2369-3

D2369-3

Parent Item Name: Locator Plate

Start Date: 12/17/2015

Required Date: 12/17/2015

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev A Removed from 9 Digit 05-12-05 JLM

IPP Rev:B Now on Waterjet 07-05-28 JLM

13.05.21 AS PER DWG REV.B VERF:JLM

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased				110	sf	51.6984	1.354	14.25263			

M5052H32S 040

5052-H32 .040 Sheet

DL 16/02/02

Location

Loc Qty

Loc Code

MAT023

51.6984

m129530

4.0984

m132546

7.6

m133550

40

15.3

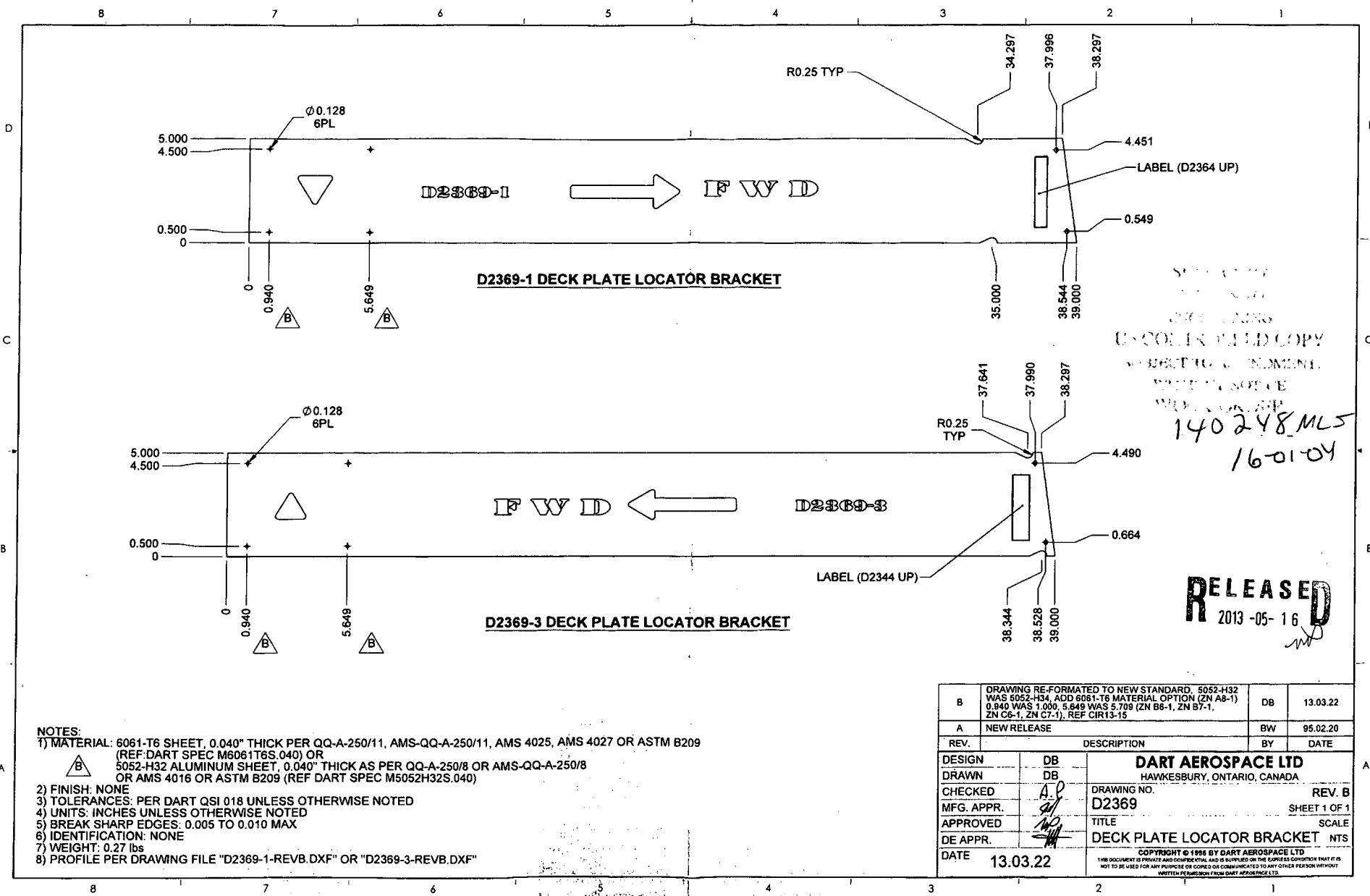
DART AEROSPACE LTD		Work Order: 190248
Description: Deck Plate Locator Bracket		Part Number: D2369-3
Inspection Dwg: D2369	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	.503	/		V-D-02	
4.500	+/-0.010	4.499	/		V-D-04	
5.649	+/-0.010	5.651	/		Tap	
Ø0.128	+0.005/-0.000	Ø.127	/			
37.990	+/-0.010	37.990	/			
38.297	+/-0.010	38.297	/			
5.000	+/-0.010	5.005	/			
4.490	+/-0.010	4.49	/			
0.664	+/-0.010	.666	/			
39.000	+/-0.010	39.000	/			
38.528	+/-0.010	38.528	/			
0.940	+/-0.010	.939	/			

Measured by: <i>Dr</i>	Audited by: <i>38</i>	Preliminary Approval:
Date: 16/02/02	Date: FEB 12 2002	Date:

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	13.06.26	Dimensions updated per Dwg Rev B	KJ	



UNCOLLECTED COPY
 140248 ML5
 160104

RELEASED
 2013-05-16

- NOTES:
- 1) MATERIAL: 6061-T6 SHEET, 0.040" THICK PER QQ-A-250/11, AMS-QQ-A-250/11, AMS 4025, AMS 4027 OR ASTM B209 (REF: DART SPEC M5052H32S.040) OR 5052-H32 ALUMINUM SHEET, 0.040" THICK AS PER QQ-A-250/8 OR AMS-QQ-A-250/8 OR AMS 4016 OR ASTM B209 (REF: DART SPEC M5052H32S.040)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.27 lbs
 - 8) PROFILE PER DRAWING FILE "D2369-1-REVB.DXF" OR "D2369-3-REVB.DXF"

B	DRAWING RE-FORMATTED TO NEW STANDARD, 5052-H32 WAS 5052-H34, ADD 6061-T6 MATERIAL OPTION (ZN A8-1) 0.940 WAS 1.000, 5.649 WAS 5.709 (ZN B6-1, ZN B7-1, ZN C6-1, ZN C7-1), REF CIR13-15	DB	13.03.22
A	NEW RELEASE	BW	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2369 REV. B SHEET 1 OF 1 TITLE DECK PLATE LOCATOR BRACKET SCALE NTS COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	DB		
CHECKED	A.P.		
MFG. APPR.	9/1		
APPROVED	140		
DE APPR.	140	DATE 13.03.22	